

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐	Folio/Program ☐	☐	Outside Dimensions ☐															
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐	Grain ☐	☐	Over/Under tolerance ☐															
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Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐	Out of Sequence ☐	☐	Part Moved ☐															
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐	Off-set ☐	☐	Drawing ☐															
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐	Mislabeled ☐	☐	Finish ☐															
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐	☐	Misread ☐															
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐	Misaligned/off center ☐	☐	Turning Sequence ☐															
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐	☐	Past Due ☐																							

151357

Friday, September 23, 2016 2:48:34 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

6

6

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

120

6

OCT 05 2016

130

Gx

16/10/13 DAS
36
9-88

140

0.02

DAS
38
~~9.88~~

OCT 14 1966

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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OTHER : ☐					

Work Order ID 151357

Friday, September 23, 2016 2:48:34 PM

151357

Page 4

Item ID: D2344 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Deck Plate Aft
Start Date: 9/19/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.01							DAS 38 9-29 OCT 24 2016
Quality Control									
180	Identify as per dwg & Stock Location: <u>St 225A</u>	0.00							
180									
Packaging	Memo	0.01							6 OCT 24 2016 DAS 6 9-29
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.10							16/10/25 OCT 25 2016
Quality Control									

DAS
21
9-29

OCT 25 2016

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OTHER :																					

Picklist Print

Friday, September 23, 2016 2:48:33 PM

Page 1

Work Order ID: 151357

151357

Parent Item: D2344

D2344

Parent Item Name: Deck Plate Aft

Start Date: 9/19/2016

Required Date: 9/23/2016

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:D00.06.26Removed P/O for powder coatEC

IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

192.2000

0.745

4.705263

M2024T3S 063

PR 10/10/03

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT

40.5

m135512

40.5

MAT009

151.7

m134640

62.1

m135032

3.2

m135612

86.4

S.0

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DART AEROSPACE LTD		Work Order: 151357
Description: Litter Deck Plate Kit (350)		Part Number: D2344
Inspection Dwg: D2344	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.229	✓		Dc-02	
5.598	+/-0.010	5.602	✓		tape	
4.869	+/-0.010	4.873	✓			
3.889	+/-0.010	3.895	✓			
3.096	+/-0.010	3.100	✓			
2.891	+/-0.010	2.895	✓			
16.973	+/-0.010	16.973	✓			
0.450	+/-0.010	0.451	✓			
4.423	+/-0.010	4.427	✓			
4.723	+/-0.010	4.721	✓			
1.202	+/-0.010	1.206	✓			
5.869	+/-0.010	5.870	✓			
4.654	+/-0.010	4.658	✓			
Ø0.656	+0.005/-0.000	0.658	✓			
1.888	+/-0.010	1.896	✓			
2.285	+/-0.010	2.291	✓			
2.683	+/-0.010	2.690	✓			
Ø0.171	+0.005/-0.000	0.172	✓			
3.491	+/-0.010	3.495	✓			
Ø0.191	+0.005/-0.000	0.192	✓			
3.123	+/-0.010	3.129	✓			
1.975	+/-0.010	1.980	✓			
Ø0.128	+0.005/-0.001	0.130	✓			

Measured by: PR	Audited by: 9-89	Prototype Approval:	N/A
Date: 10/10/03	Date: OCT 05 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	

